

Date: Thursday, 3/22/2007 2:41:46 PM  
User: Kim Johnston

ASAP HS

# Process Sheet

|                       |  |                  |               |
|-----------------------|--|------------------|---------------|
| Customer              | : CU-DAR001 Dart Helicopters Services            | Drawing Name     | : ANGLE       |
| Job Number            | : 31441  |                  |               |
| Estimate Number       | : 10198  |                  |               |
| P.O. Number           | : N/A  | Part Number      | : D21752      |
| This Issue            | : 3/22/2007 S.O. No. : N/A                       | Drawing Number   | : D2175 REV E |
| Prsht Rev.            | : NC   | Project Number   | : N/A         |
| First Issue           | : N/A  | Drawing Revision | : E           |
| Previous Run          | : 26496  | Material         | : N/A         |
|                       |  | Due Date         | : 3/30/2007   |
| Written By            | :  | Qty:             | 39            |
| Checked & Approved By | : <u>07.03.22</u>                                | Um:              | 40            |
| Comment               | Each   |                  |               |
|                       | Est E 04.06.09 Reformat KJ/RF                    |                  |               |
|                       | Est Rev:F 06-04-28 Manufactured on Water Jet JLM |                  |               |
|                       | Est Rev:G As per Rev E 06-11-22 JLM              |                  |               |

## Additional Product

Job Number:



Seq. # Machine Or Operation: Description :

1.0 M2024T3S063 2024-T3 .063 sheet



Comment: Qty.: 0.4958 sf(s)/Unit Total : 19.8324 sf(s)

Material: 2024-T3 (QQ-A-250/4) 0.063" thick  
(M2024T3S.063)

Batch: 4103321

07 03 26

(39)

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D2175

Dwg Rev: E

Prog Rev: E

07 03 26

(39)

2-Deburr if necessary

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

07 03 26

(39)

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

07/03/28

(39)

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr Stack

07/03/28

(39)

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ \_\_\_\_\_ Date: 07/03/20  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

NOTE: Date & initial all entries

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: ANGLE

Job Number: 31441

Part Number: D21752

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/03/29

(39)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07-03-29

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

07-03-29

07-03-29

(39)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

SB

07/03/29

(39)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SB

07/03/29

(39)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(39)

07/03/30

Job Completion



07-03-30

# Dart Aerospace Ltd

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

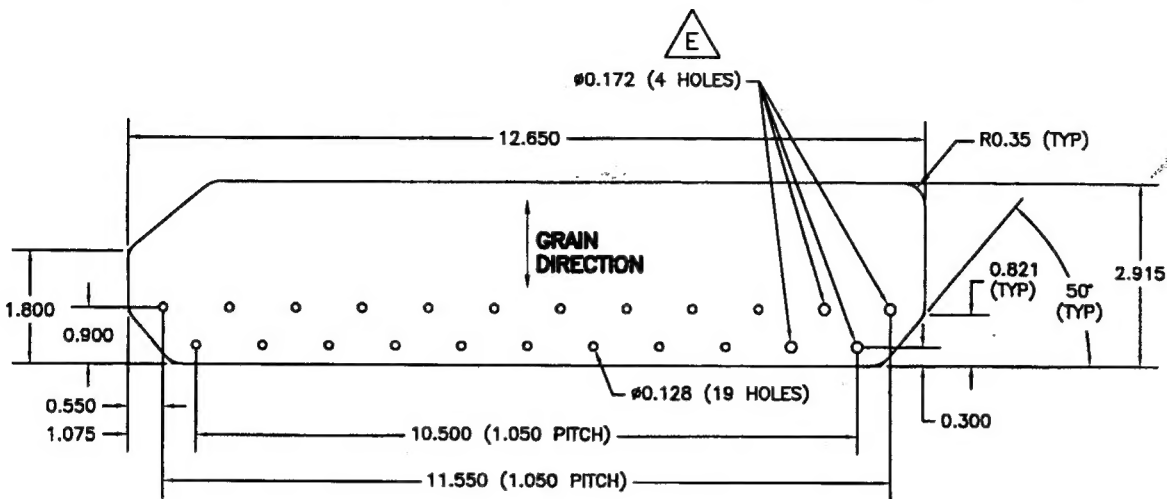
**NOTE:** Date & initial all entries



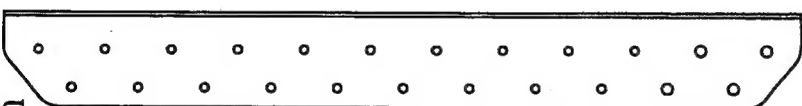


RELEASED  
06.10.13

| DESIGN           | DRAWN BY                | DART AEROSPACE LTD              |              |
|------------------|-------------------------|---------------------------------|--------------|
| RF               | CE                      | HAMKESBURY, ONTARIO, CANADA     |              |
| CHECKED<br>PH    | APPROVED<br>[Signature] | DRAWING NO.                     | REV. E       |
| DATE<br>06.09.25 |                         | D2175                           | SHEET 1 OF 1 |
|                  |                         | TITLE                           | SCALE        |
|                  |                         | ANGLE                           | 1:3          |
| A                | 95.10.25                | NEW ISSUE                       |              |
| B                | 96.01.18                | CHANGED DIMENSION               |              |
| C                | 00.09.11                | UPDATE FINISH SPEC              |              |
| D                | 04.06.03                | RE-DESIGN                       |              |
| E                | 06.09.25                | INC HOLE DIA TO Ø0.172, 4 HOLES |              |



**D2175-1F FLAT PATTERN**



**D2175-1 BEND DETAIL SHOWN  
(D2175-2 BENT OPPOSITE)**

**NOTES:**

- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY  
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WITHOUT NOTICE  
WORK ORDER  
NO. 31441

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